

16

Date: Tuesday, 3/11/2008 11:27:41 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : GHW MOD KIT
 Job Number : 37805
 Estimate Number : 11182
 P.O. Number :
 This Issue : 3/11/2008 S.O. No. :
 Prsht Rev. : NC
 First Issue : 11 Type : SMALL /MED FAB
 Previous Run : 36775
 Written By :
 Checked & Approved By : 08 03 11
 Comment : Est Rev:K Removed Manufacturing 05-12-05 JLM

Part Number : D350615041
 Drawing Number : D350-615
 Project Number : N/A
 Drawing Revision : B
 Material :
 Due Date : 4/18/2008 Qty: 100 Um: Each

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL
 Photocopy bluefile and type labels (2 GHW Kits per box) as per PPP D350-615-041 CHG003

JLD 08.4.17

08/08/11

2.0 37805A "T" HANDLE ASSEMBLY



Comment: Sub-Component "T" HANDLE ASSEMBLY
 D2282-041 B 37805A

08/06/11

3.0 37805B SADDLE ASSEMBLY



Comment: Sub-Component SADDLE ASSEMBLY
 D2282-043 B 37805B

08/06/11

4.0 D30153 Lock Nut



Comment: Qty.: 3.0000 Each(s)/Unit Total: 300.0000 Each(s)
 Pick: 20
 Qty Part Number Description Batch
 3 D3015-3 5/16 Locknut B37840

KS 08/05/20

5.0 D30155 SS Nylock Nut 7/16



Comment: Qty.: 1.0000 Each(s)/Unit Total: 100.0000 Each(s)
 Pick:
 Qty Part Number Description Batch
 1 D3015-5 7/16 Locknut B37770

KS 08/05/20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 3/11/2008 11:27:41 AM
User: Kim Johnston

Process Sheet

Customer: •CU-DAR001 Dart Helicopters Services

Bring Back
what is not
used. $\frac{360}{210} = 90$
51618015C

Job Number: 37805

Job Number:



Seq. #: Machine Or Operation:

6.0 51618015C



Comment: Qty.: 3.0000 Each(s)/Unit Total: 300.0000 Each(s)
Pick: ~~210~~

Qty Part Number Description Batch

3 5/16-18-015C 5/16 Bolt 1.5 Long

~~M106869~~
M107778

JS 08/05/20 (x70)

7.0 516WC SS Flat Washer 5/16



Comment: Qty.: 12.0000 Each(s)/Unit Total: 1200.0000 Each(s)
Pick: 840

Qty Part Number Description Batch

12 5/16WC 5/16 Flat Washer

~~M106869~~ 107541

JS 08/05/20 (x70)

8.0 71614050C SS Bolt 7/16 5" Long



Comment: Qty.: 1.0000 Each(s)/Unit Total: 100.0000 Each(s)
Pick:

Qty Part Number Description Batch

1 7/16-14-050C 7/16 Bolt 5.0 Long

M106861

JS 08/05/20 (x70)

9.0 716WC SS Flat Washer 7/16



Comment: Qty.: 2.0000 Each(s)/Unit Total: 200.0000 Each(s)
Pick: 140

Qty Part Number Description Batch

2 7/16wc 7/16 Washer

1 D2282-041(Ref) "T" Handle Assembly

1 D2282-043 (Ref) Saddle Assembly

M106886
3 7805A
3 7805B

M107802 (10x)

JS 08/05/20 (x70)

10.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble D2282-041 with D2282-043 as per Dwg D350-615 Only engage one thread on three 5/16-18-015C bolts

JS 08/06/11 (x72)

11.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

JS 08/06/11 (x72)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 3/11/2008 11:27:41 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: GHW MOD KIT

Job Number: 37805

Part Number: D350615041

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



72
08/06/11
36

Comment: INSPECT 100% KITS FOR COMPLETENESS

13.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D350-615:041

Location: _____

PPP Rev: _____

E

8/6/11

50

72
36

14.0

QC21

FINAL INSPECTION/W/O RELEASE



08/06/12

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



08/06/12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN BW	DRAWN BY KE	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED DIB	APPROVED BW	DRAWING NO. D350-615	REV. B SHEET 1 OF 2
DATE 97.10.21		TITLE GROUND HANDLING WHEEL MOD.	SCALE NTS
A	95.03.23	NEW ISSUE	
B	97.10.21	CHANGE NUMBERING SCHEME	

-041	Part No.	Description
X	D350-615-041	Ground Handling Wheel Mod.
1	D2282-041	"T" ASSEMBLY
1	D2282-043	SADDLE ASSEMBLY
3	5/16-18-015C	5/16 BOLT 1.5 LONG
3	5/16-18NC	5/16 LOCKNUT (D3015-3)
12	5/16WC	5/16 WASHER
1	7/16-14-050C	7/16 BOLT 5.0 LONG
1	7/16-14NC	7/16 LOCKNUT (D3015-5)
2	7/16WC	7/16 WASHER

THESE INSTRUCTIONS ARE TO BE USED IN CONJUNCTION WITH
THE AIRCRAFT MAINTENANCE AND OVERHAUL INSTRUCTION MANUAL
AC43.13.1A & 2A ACCEPTABLE METHODS, TECHNIQUES, AND PRACTICES

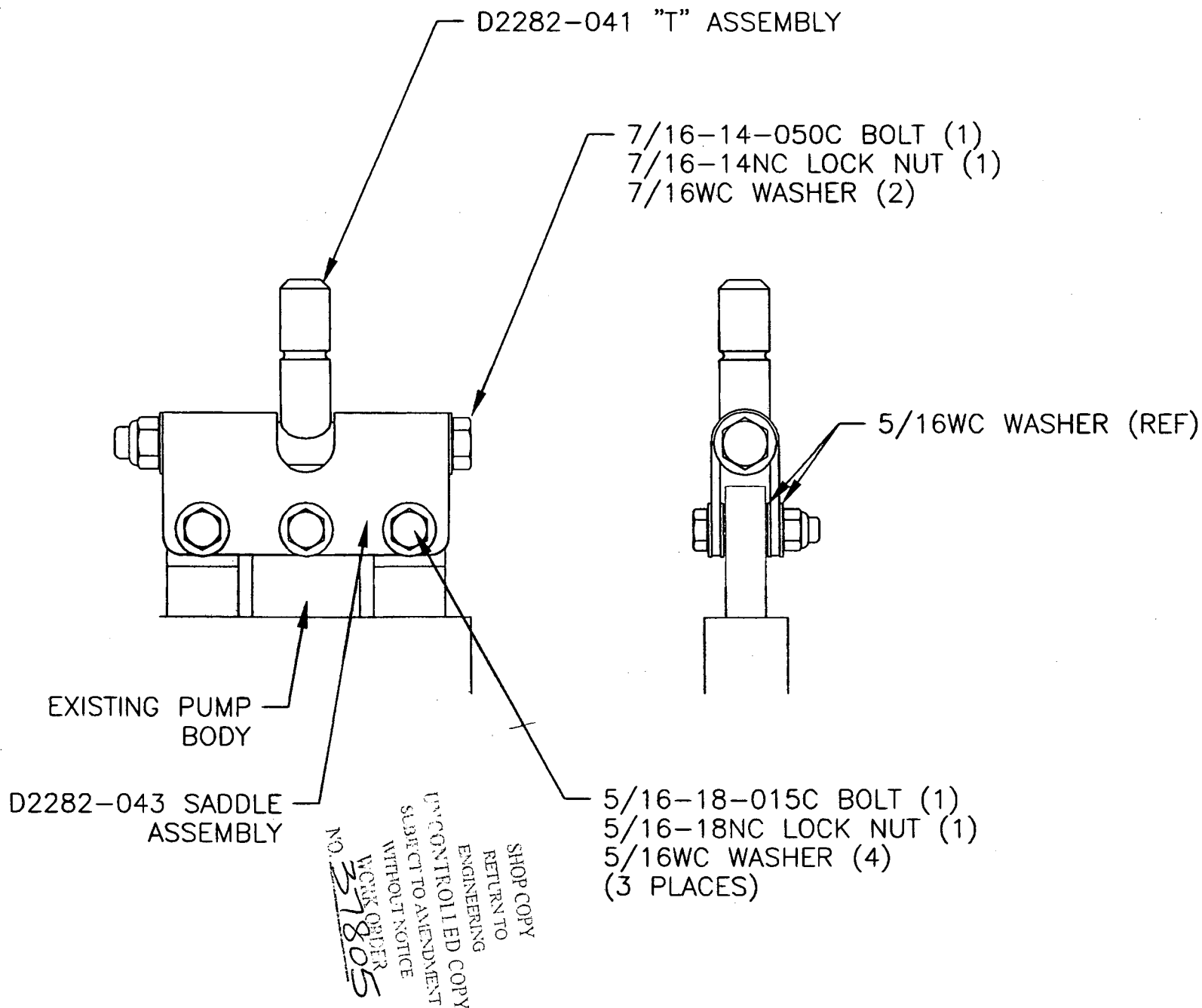
INSTALLATION:

1. Remove existing ground handling wheel pump saddle.
2. Replace saddle with D350-615-041.
3. Torque 5/16 bolts to bottom, then back-off half turn to allow easy rotation without excessive play.

SHOP COPY
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 37805

DART

DESIGN	EW	DRAWN BY	KE	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	REV. B
CHECKED	<i>[Signature]</i>	APPROVED	EW	DRAWING NO. D350-615	SHEET 2 OF 2
DATE	97.10.21	TITLE	GROUND HANDLING WHEEL MOD.	SCALE	NTS



16

Date: Tuesday, 3/11/2008 11:27:44 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : "T" HANDLE ASSEMBLY
 Job Number : 37805A
 Estimate Number : 11179
 P.O. Number :
 This Issue : 3/11/2008 S.O. No. :
 Prsh: Rev. : NC Part Number : D2282041
 First Issue : 11 Type : SMALL /MED FAB Drawing Number : D2282 REV E
 Previous Run : 36775A Drawing Revision : E
 Material :
 Written By : Due Date : 4/18/2008 Qty: 100 Um: Each
 Checked & Approved By : 08 03 11
 Comment : Est Rev: A Removed from 9 Digit 05-12-02 /JLM

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D22823 Tube



Comment: Qty.: 1.0000 Each(s)/Unit Total : 100.0000 Each(s)

Pick:

Qty Part Number

Description Batch

1 D2282-3

Handle tube 335472

08.05.22

72

2.0 D22825 Tube



Comment: Qty.: 1.0000 Each(s)/Unit Total : 100.0000 Each(s)

Pick:

Qty Part Number

Description Batch

1 D2282-5

Handle tube 336774

08.05.22

72

3.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Weld as per D2282-041 'T' Handle Assembly

Grind chamfers and ensure full penetration.

A/R ER316L SS

Filling Rod 11071051

Dwg Rev: E

08.05.23

72

4.0 QC9 VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

PD 08-05-26 (72)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 3/11/2008 11:27:44 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: "T" HANDLE ASSEMBLY

Job Number: 37805A

Part Number: D2282041

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Tumble

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: G-A

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



u 08-06-10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

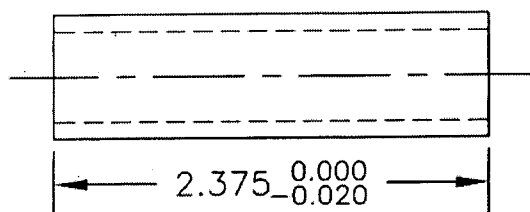
NOTE: Date & initial all entries



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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2282	REV. E SHEET 1 OF 2
DATE 05.06.07	TITLE HANDLE TUBES		SCALE 1:1
A	94.10.14	NEW ISSUE	
B	95.03.23	RE-DESIGN	
C	97.10.20	CORRECTED NUMBERING SCHEME	
D	05.03.16	REDESIGN D2282-5; 0.795 WAS 0.750	
E	05.06.07	D2282-5 304 SS WAS 303 SS; R0.063 x 0.063 WAS R0.080 x 0.030	

RELEASED
[Signature]

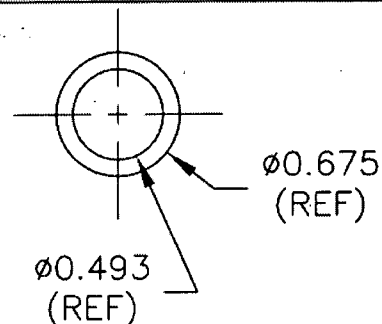
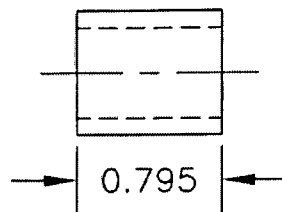
05/09/16



D2282-3

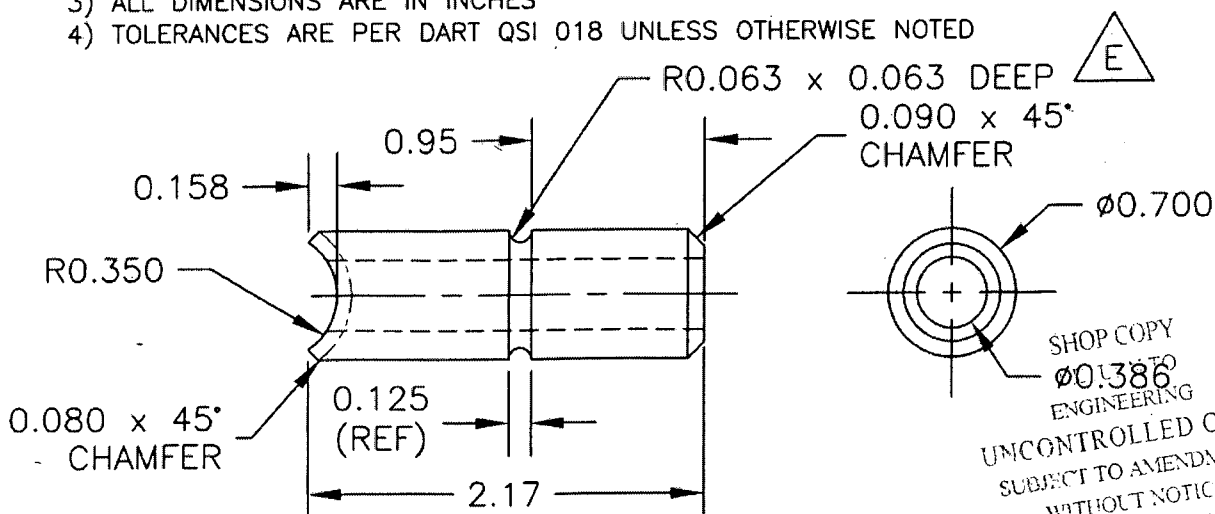


D2282-7



D2282-3/-7 TUBE:

- 1) MATERIAL: T304/T316 3/8 SCHEDULE 40 (REF. DART SPEC. M304TR0.675W.091)
- 2) BREAK ALL UMARKED SHARP EDGES 0.005 TO 0.010
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



D2282-5

D2282-5 STEM:

- 1) MATERIAL: AISI 304 STAINLESS STEEL (REF. DART SPEC. M304R0.750)
- 2) BREAK ALL UMARKED SHARP EDGES 0.005 TO 0.010
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

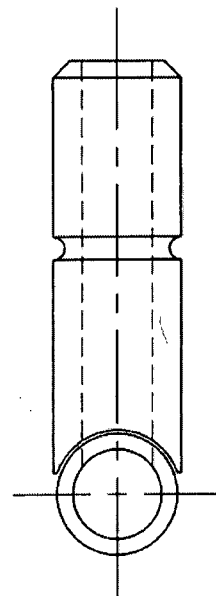
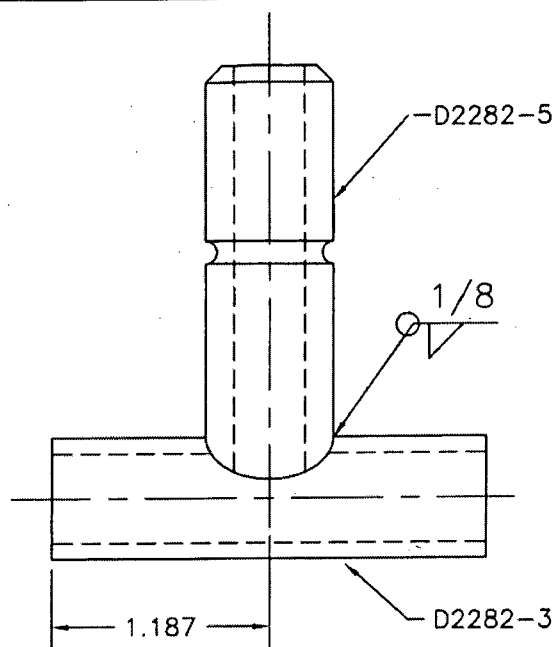


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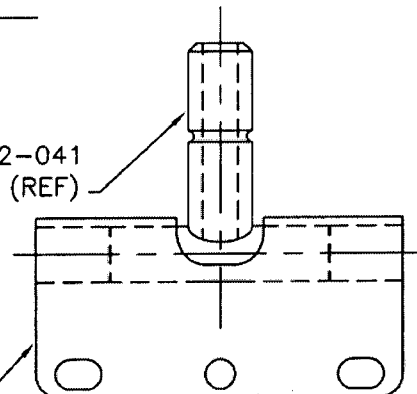
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DATE 05.06.07	TITLE HANDLE TUBES		SCALE 1:1

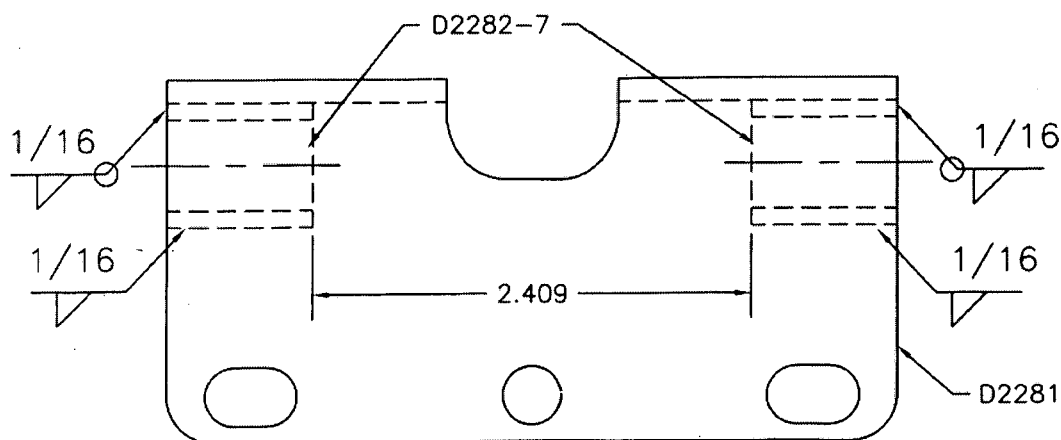


D2282-041
(REF)



D2282-043
(REF)

GENERAL ASSEMBLY
SCALE 1:2



D2282-043 SADDLE ASSEMBLY
WELD ASSEMBLY PER DART QSI 004

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Date: Tuesday, 3/11/2008 11:27:46 AM
User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : SADDLE ASSEMBLY
Job Number : 37805B
Estimate Number : 11180
P.O. Number :
This Issue : 3/11/2008 S.O. No. :
Prsht Rev. : NC Part Number : D2282043
First Issue : 11 Type : SMALL /MED FAB Drawing Number : D2282 REV E
Previous Run : 36775B Material :
Written By : Due Date : 4/18/2008 Qty: 30 Um: Each
Checked & Approved By :
Comment : Est Rev: A Removed from 9 Digit 05-12-02 JLM

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D2281 Jack Saddle



Comment: Qty.: 1.0000 Each(s)/Unit Total : 100.0000 Each(s)

Pick:

Qty Part Number Description Batch
1 D2281 Saddle 337445

08.05.23

72

2.0 D22827 Tube



Comment: Qty.: 2.0000 Each(s)/Unit Total : 200.0000 Each(s)

Pick:

Qty Part Number Description Batch
2 D2282-7 tube 323977 = 21
337850 = 119

08.05.23

72

3.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Weld as per D2282-043 Saddle Assembly
Grind chamfers and ensure full penetration.

A/R ER316L SS Filling Rod M107051
Dwg Rev: E

SAD 08/06/02

08.05.28

72

4.0 QC9 VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

PD 08.05.05

72

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 3/11/2008 11:27:46 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE ASSEMBLY

Job Number: 37805B

Part Number: D2282043

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Tumble

INSPECT WORK TO CURRENT STEP

6.0

QC5



Comment: INSPECT WORK TO CURRENT STEP

08/06/10 (72) counts

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/06/10

Job Completion



08/06/10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

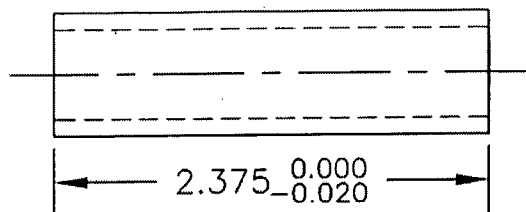
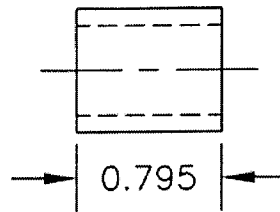
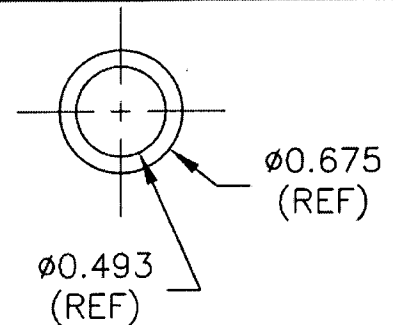
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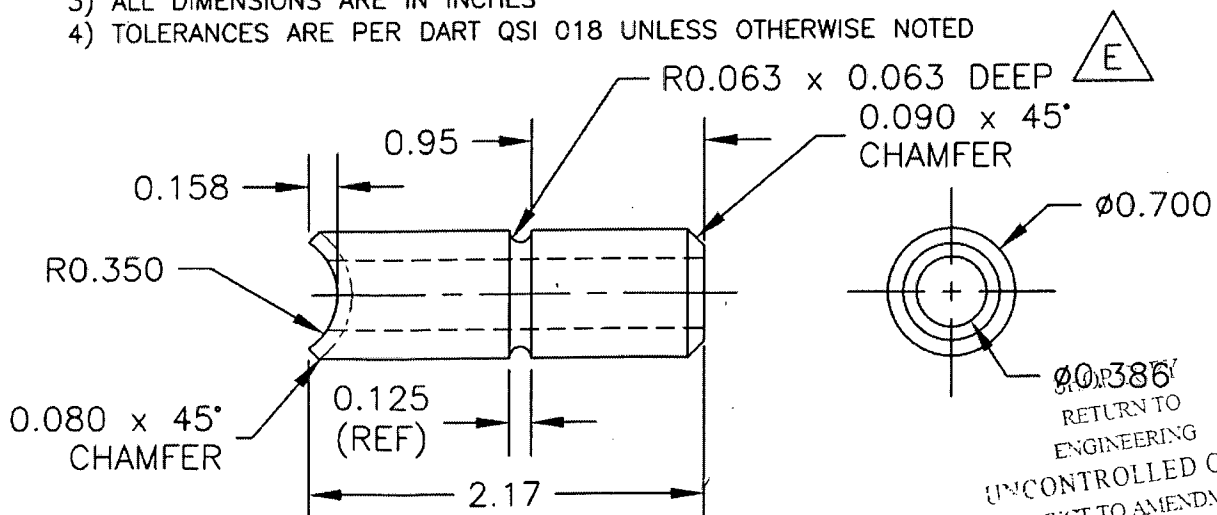
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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2282	REV. E SHEET 1 OF 2
DATE 05.06.07	TITLE HANDLE TUBES		SCALE 1:1
A	94.10.14	NEW ISSUE	
B	95.03.23	RE-DESIGN	
C	97.10.20	CORRECTED NUMBERING SCHEME	
D	05.03.16	REDESIGN D2282-5; 0.795 WAS 0.750	
E	05.06.07	D2282-5 304 SS WAS 303 SS; R0.063 x 0.063 WAS R0.080 x 0.030	

RELEASED

05/09/16

**D2282-3****D2282-7****D2282-3/-7 TUBE:**

- 1) MATERIAL: T304/T316 3/8 SCHEDULE 40 (REF. DART SPEC. M304TR0.675W.091)
- 2) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

**D2282-5****D2282-5 STEM:**

- 1) MATERIAL: AISI 304 STAINLESS STEEL (REF. DART SPEC. M304R0.750)
- 2) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

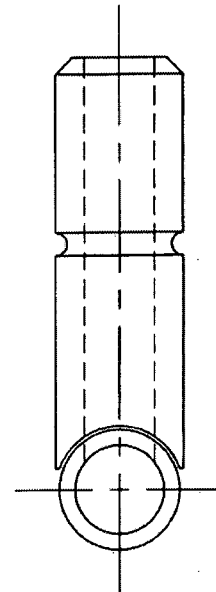
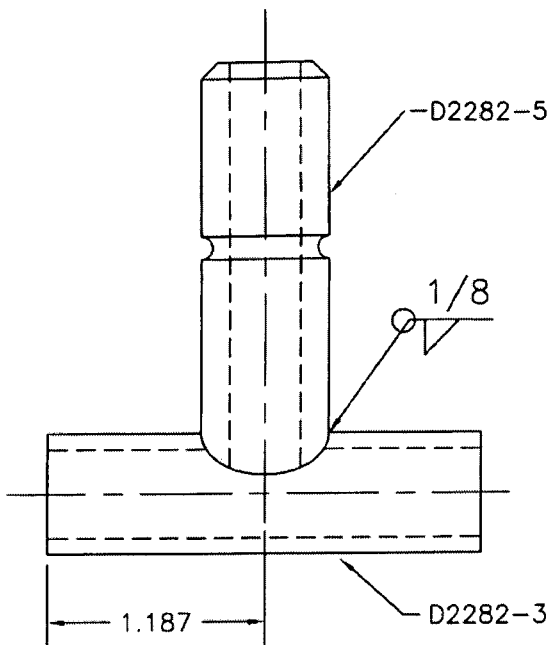
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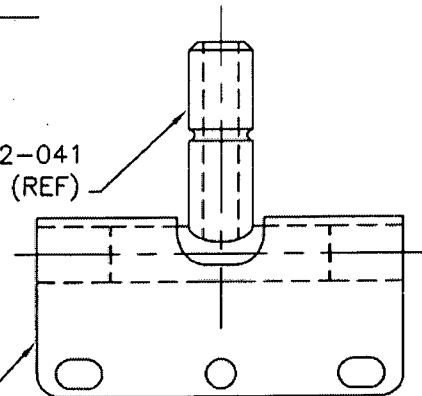
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CHECKED <i>UP</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2282	REV. E SHEET 2 OF 2
DATE 05.06.07	TITLE HANDLE TUBES		SCALE 1:1



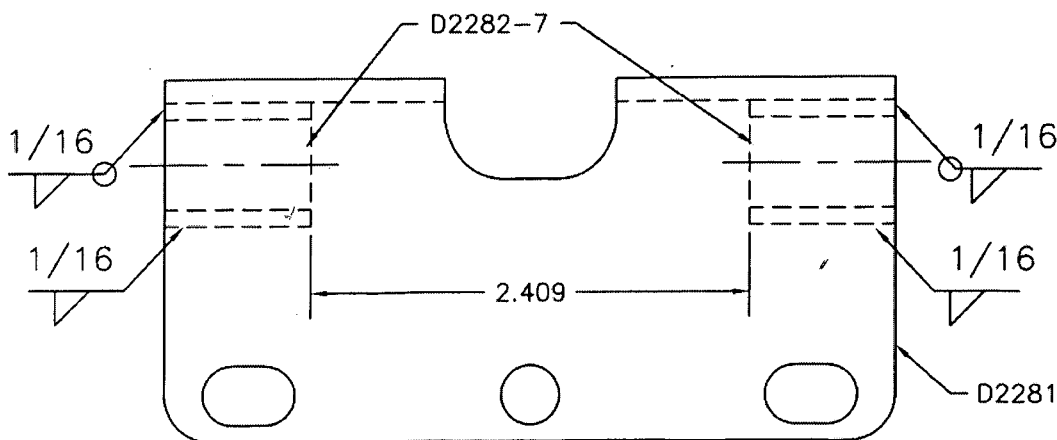
D2282-041
(REF)

D2282-041 'T' ASSEMBLY
WELD ASSEMBLY PER DART QSI 004

D2282-043
(REF)



GENERAL ASSEMBLY
SCALE 1:2



D2282-043 SADDLE ASSEMBLY
WELD ASSEMBLY PER DART QSI 004

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